

Date: Tuesday, 10/03/2009 10:50:46 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 212/205 HIGH AFT X-TUBE ASSEMBLY
<b>Job Number</b> : 46386	
<b>Estimate Number</b> : 13218	
<b>P.O. Number</b> :	<b>Part Number</b> : D212664201TRN
<b>This Issue</b> : 10/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D212-664-241 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : CROSSTUBES	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 44745	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 17/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.03.10</u>	
<b>Comment</b> : Est Rev:A 08-03-06 new issue DD verified by:ec Est Rev B 08.04.02 Removed polish EC verified DD	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6006129	Crosstube Material
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch  
 1 D6006-129 Crosstube 538338  
 Check OD = 3.250"; ID = 2.220"

A.M 09.03.12 ①

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3- File transition lines smooth.

A.M 09.03.12 ①

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

A.M 09.03.12 ①

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

2- File transition lines smooth.

3-Remove sand and plugs

A.M 09.03.12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/03/2009 10:50:46 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 46386

Part Number: D212664201TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

4- scribe batch # and part # as per dwg

*Q.M 09.03.12 ①*

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*Q.M 09.03.12 ①*

6.0

QC8

SECOND CHECK



*Ann 9-3-16*



*①*

Comment: SECOND CHECK

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*Ann 9-3-16*



*①*

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DP*

*9-3-16*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and stock in kanban rack

Location:

*X-TUBE CELL Ann 9-3-16*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*①*  
*AD09103115*

Job Completion



*W 09.03.16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> H6386
<b>Description:</b> Crosstube Assembly (205/212 High Aft)		<b>Part Number:</b> D212-664-241
<b>Inspection Dwg:</b> D212-664-241 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	0.200	✓			
	R0.063	+/-0.010	R0.063	✓			
	2.990	+0.005/-0.000	2.993	✓			
	5.237	+/-0.030	5.237	✓			
	2.600	+0.005/-0.000	2.605	✓			
	2.686	+0.005/-0.000	2.691	✓			
	2.770	+0.005/-0.000	2.775	✓			
	2.854	+0.005/-0.000	2.859	✓			
	2.938	+0.005/-0.000	2.943	✓			
	3.021	+0.005/-0.000	3.026	✓			
	3.133	+0.005/-0.000	3.136	✓			
	3.179	+0.005/-0.000	3.182	✓			
SIDE B	0.200	+/-0.010	0.200	✓			
	R0.063	+/-0.010	R0.063	✓			
	2.990	+0.005/-0.000	2.995	✓			
	5.237	+/-0.030	5.237	✓			
	2.600	+0.005/-0.000	2.605	✓			
	2.686	+0.005/-0.000	2.691	✓			
	2.770	+0.005/-0.000	2.775	✓			
	2.854	+0.005/-0.000	2.859	✓			
	2.938	+0.005/-0.000	2.943	✓			
	3.021	+0.005/-0.000	3.026	✓			
	3.133	+0.005/-0.000	3.136	✓			
	3.179	+0.005/-0.000	3.183	✓			
	124.36	+/-0.020	124.370	✓			

<b>Measured by:</b> O.m	<b>Audited by:</b> ANM	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09.03.12	<b>Date:</b> 9-3-16	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D212-664-241	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

**RELEASED**  
07.04.24  
PER E.C.N 285

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
4	MS21920-28	CLAMP (OR MS21920-30)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

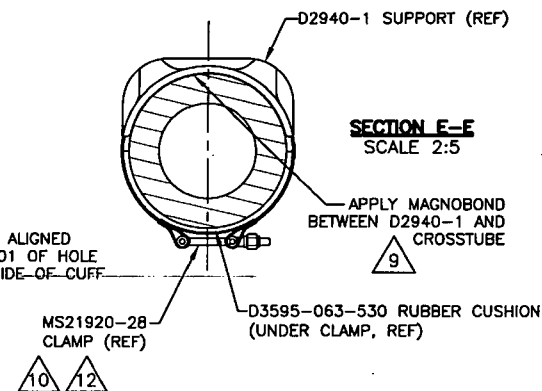
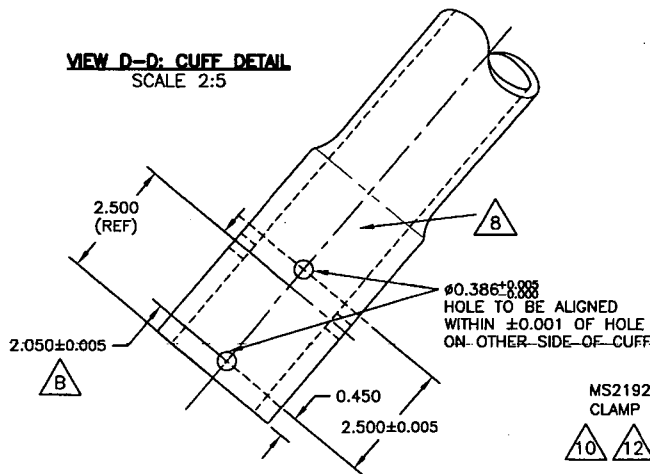
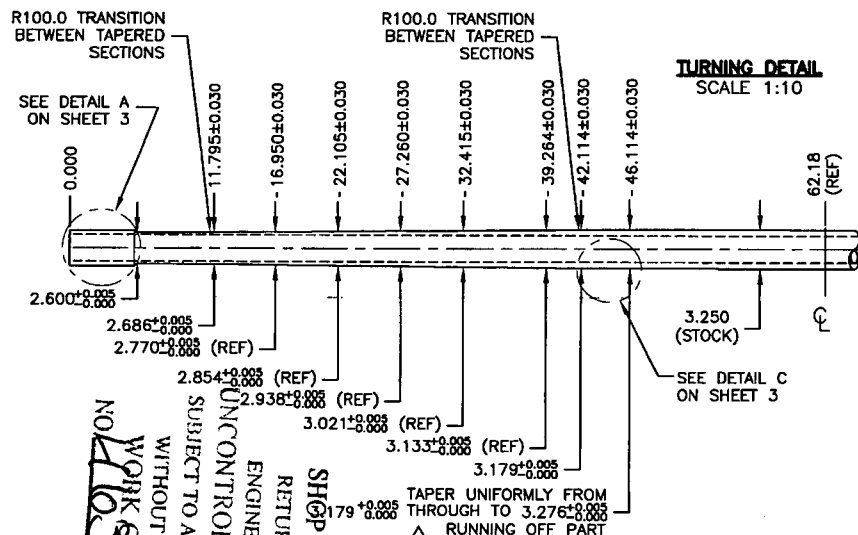
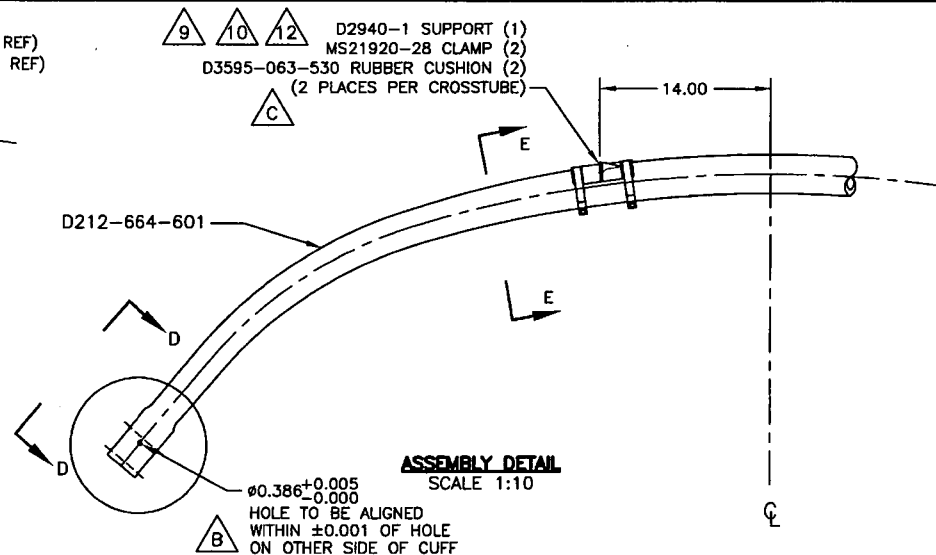
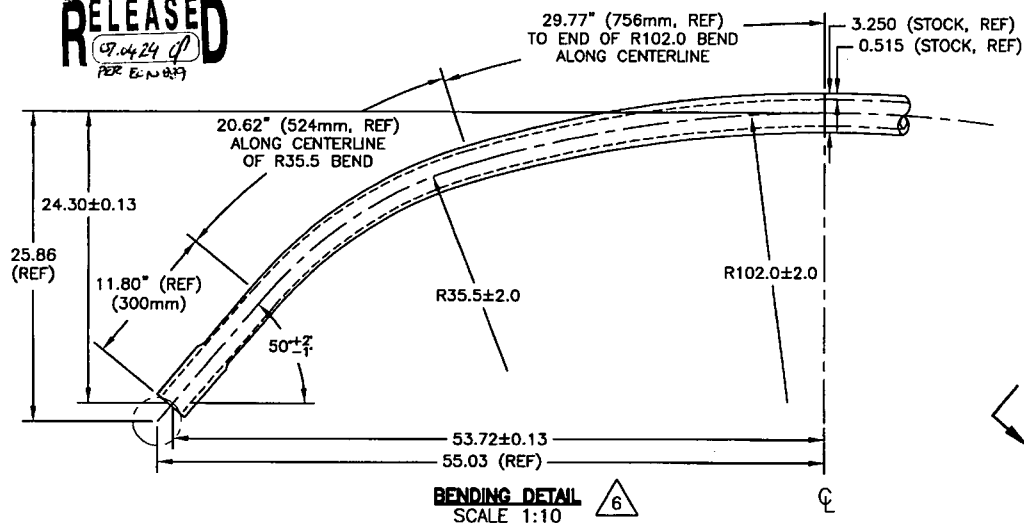
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129  
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT  
**NOTE:** MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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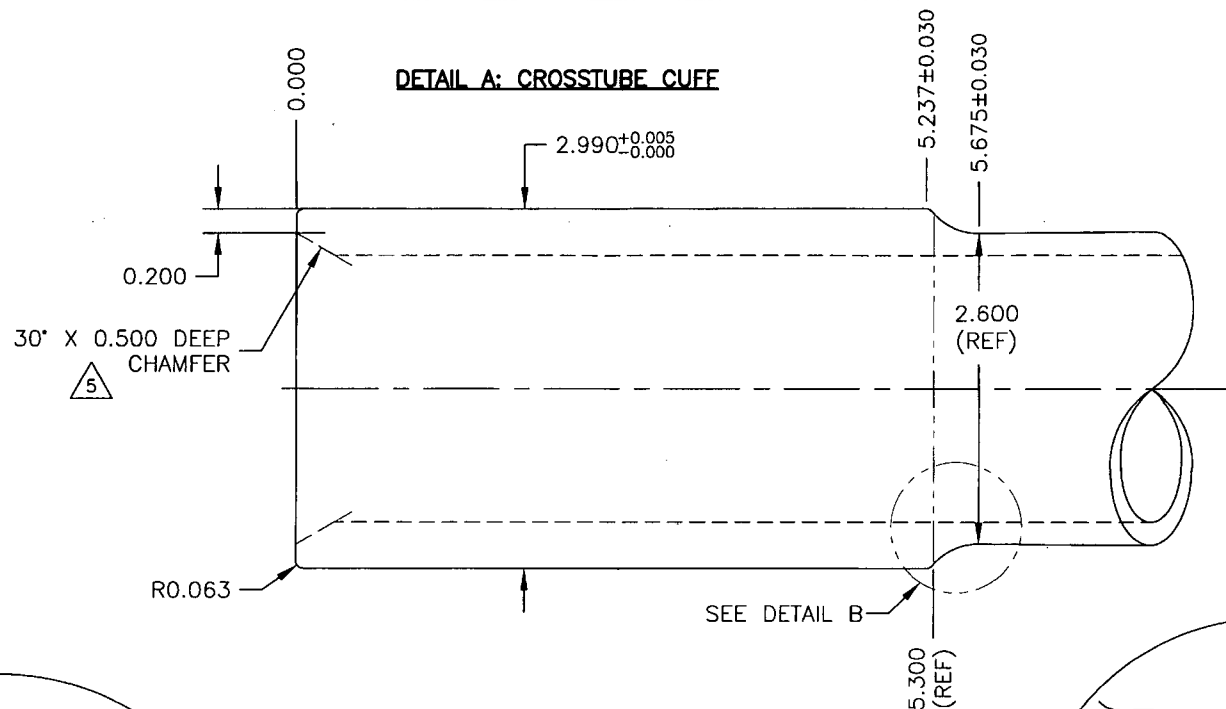
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CHECKED	J	APPROVED	J
DATE	07.03.08		

<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
DRAWING NO. D212-664-241	REV. C SHEET 2 OF 3
TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:10

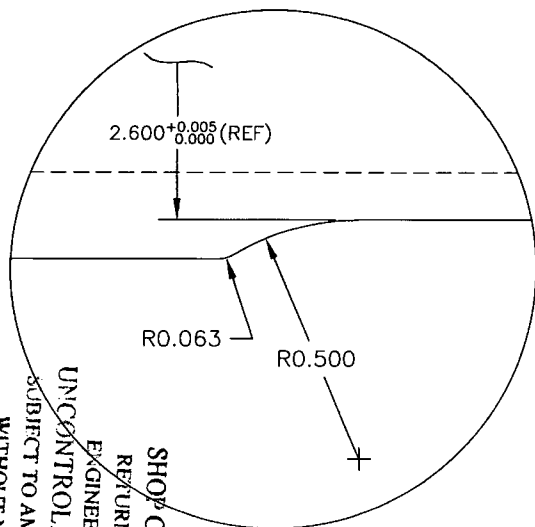
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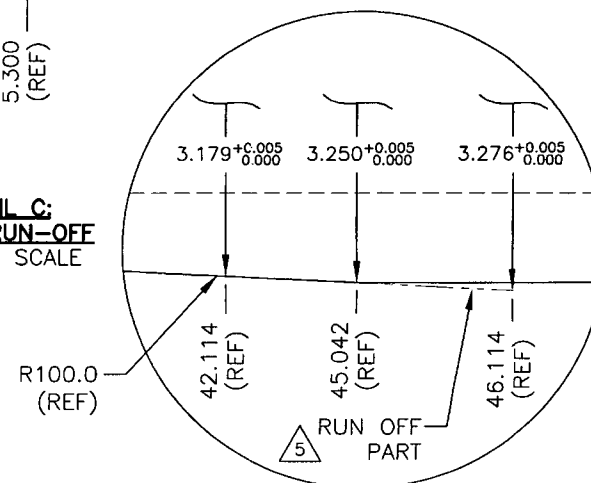
**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
TRANSITION  
SCALE 4:1**



**DETAIL C:  
TAPER RUN-OFF  
NOT TO SCALE**



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DATE 07.03.08		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)			SCALE 1:1